

The listing of the claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (Currently Amended): Method for producing a piston

(1) for an internal combustion engine,

- having an essentially cylindrical base body (4) made of aluminum, whose one face forms a piston crown (5),
- having pin bosses (8) with pin bores (3) disposed on the underside of the base body (4), facing away from the piston crown (5), and having skirt elements (9) that connect the pin bosses (8) with one another, ~~characterized in that~~
wherein

- the base body (4) is produced using the forging method, whereby a recess (22) is formed into the radially outer region of the piston crown (5),

- that the free shanks (13, 14) of an essentially toroid-shaped cooling channel (15), which is C-shaped in cross-section and radially open to the outside, and produced from sheet steel, are welded onto a cylindrical surface (12) of a ring insert (10) made of NiResist, which surface lies radially on the inside,

- that the ring insert (10) provided with the cooling channel (15) is cast into a ring element (6) made of aluminum, using

the composite casting method, which ring element is given such a shape, in this connection, that it fits into the recess (22),

- that the ring element (6) is fitted into the recess (22) and welded to the base body (4), and
- that the piston (1) is given its final shape by means of a cutting production method.

Claim 2 (Currently Amended): Method for producing a piston (1) for an internal combustion engine, according to claim 1, ~~characterized in that~~ wherein a recess (22) that is rectangular in cross-section is formed into the radially outer edge region of the piston crown (5), and that the ring element (6) is given a shape that is rectangular in cross-section, so that it fits into the recess (22).

Claim 3 (Currently Amended): Method for producing a piston (1) for an internal combustion engine, according to claim 1, ~~characterized in that~~ wherein the ring element (6) is given such a shape that its surface that lies radially on the inside forms a weld seam (21), with the base body (4), that narrows conically towards the piston crown (5).

Claim 4 (Currently Amended): Method for producing a piston (1) for an internal combustion engine, according to claim 1 ~~or 3, characterized in that~~ wherein the ring element (6) is given such a shape that its surface that lies axially in the direction of the pin bore (3) forms a weld seam (20), with the base body (4), that has an orientation that deviates from the radial axis direction.